

Work Order ID 80765

80765

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February-28-12 1:20:36 PM

Item ID: D6101-003 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Billet, 7075
 Start Date: 28/02/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 13/03/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/28 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D6101	Rev B

100	PURCHASING	0.00
100		
Purchasing	Memo	0.00
Purchasing	Issue P/O: <u>16302</u>	

a) Description: Aluminum billet
 b) 7.875" x 6.250" x 2.00" thick
 c) Tolerance on all dimensions are +0.030"/-0.000"
 d) Grain direction along 7.875" length
 e) Material: 7075-T7351 (QQ-A-250/12)
 f) Material certification required

01202-29
50

110	Receive & Inspect for Damage & Mat'l Certs	0.00
110		
Packaging	Memo	0.00
Packaging	Ensure material certification is attached	

C143/12 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6101								
130	Identify as per dwg & Stock Location: <u>MAT42</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80765

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Parent Item: D6101-003

D6101-003

Parent Item Name: Saddle Billet, 7075

Start Date: 28/02/2012

Required Date: 13/03/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A: 01.05.04New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003P		Purchased	No			110	Each	0.0000	1	50			

D6101-003P

7075-T7351 2X6.25X7.875

**

10/2/3/12 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

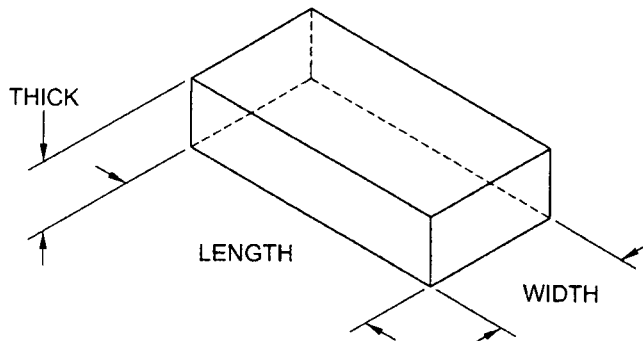
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



80765 MLJ
12/02/28

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/W

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. B	
MFG. APPR.	<i>[Signature]</i>	D6101 SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE SCALE	
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075 NTS	
DATE	09.04.23	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

B I L L O F L A D I N G
Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

No: PEC 756260
Ship Date 07Mar12 at 17:59 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

=====

B I L L O F L A D I N G

1) Our Order PEC-424965- 1 Your PO # 16302
ALUMINUM PLATE 7075-T7351 USI
2.00" THICK X 6.2500" X 7.8700"
GRAIN DIRECTION TOWARD 7.875"

Heat Number	Tag No	Quantity	PCS	Wt LBS
346081	518400	17.08 SFT	50	498

2) Our Order PEC-424965- 2 Your PO # 16302
ALUMINUM PLATE 7075-T7351 USI
2.00" THICK X 6.0000" X 6.2500"

Heat Number	Tag No	Quantity	PCS	Wt LBS
346081	518401	13.02 SFT	50	380

TOTAL:	Tags	PCS	LBS
	2	100	878

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.

ATTN: CHANTAL/LINDA

** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **

** REFERENCED ON IT **

TOTAL (1,2) 2 SKIDS GW. 928 LBS

*CUSTOMER PICK-UP HRS AT THYSSENKRUPP MATERIALS NA
CONCORD, ONT.* *** 9:00 AM TO 4:00 PM ***
**** TEL. 800-926-2600 ****

Page: 1Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT.

ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY

RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722
Ship From: RIVERDALE, IA.

Terrence Thom
Quality Assurance Manager

ThyssenKrupp Materials NA, Inc.
Copper and Brass Sales Div sold to:
CUSTOMER: ThyssenKrupp Materials
YOUR PO#: PEC 1237319
CBS ORDER#: 1401098777
QTY: 50 PC
BY: 11 DATE: 3/1/12

James H. Baker

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

1331760 0
Ship Date B.L. No. Invoice No. Alcoa No. Item
2012-01-17 6682371 00000 1000346655-2 DP-46655-
P.O. No./Govt Contract No. Customer Alcoa Item
5400125649 C&B G041043515R15

Page 1 of 2

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DR
WALLINGFORD 06492 CT

Item Description
2.0 IN TK (+.060 -.060) X 60.5 IN W (+.375 -
0.000) X 144.5 IN LN (+.5 -0.0) (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, US1 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED ALFLR01031. EXC_MRK AMS-QQ-A-250/12 IS 2007 EXC_MRK AMS-STD-
2154 IS 2010 AMS4078 REV J EXC_MRK ASTM209 REV
10 EXC_MRK BSS7055 REV A EXC_MRK CMMPO25 REV U
EXC_MRK GAMP9101 REV B EXC_MRK MMS159 REV P
EXC_MRK PS21211 REV L ((MARKED)) KRAFT PAPER
INTERLEAVED MAX
GROSS SKID WGT: 5000 LB QUAN TOL +/-30 %
US1 CL A 3 MM CQR 0201475 REV 14 CUST REQ 12-01-
18 *** W/E 12-01-21 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	372021	346081	3538	2	PC	47114

Notes for CQR: 0201475.14
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PROD UCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.
PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE
REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.

CQR: 0201475.14 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
T7351	Long Transv.	KSI	KSI	PCT
		Max	68.9	
		Min	69.0	57.0

T7351 Elec. Cond. (EC) % MIN 38.0 PCT

ThyssenKrupp Materials NA, Inc
Copper and Brass Sales Div sold to:
CUSTOMER: ThyssenKrupp Materials - WA Ecac
YOUR PO# PEC-237319
CIS ORDER# 1401098277
QTY: 50PCS
BY: AS DATE: 3/1/12

Cust: THYSSENKRUPP MATERIALS NA - ECAD Del: 2401728619
Part: PO: PEC - 237319
Wgt: 497.937 LB Date: 03/02/2012

James H. Baker

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per:

Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

1331760	0		
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item
2012-01-17	6682371	00000	1000346655-2 DP-46655-2
P.O. No./Govt Contract No.	Customer		Alcoa Item
540012649	C&B	G041043515R15	

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CQR: 0201475.14 -Specification Limits (cont.)

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 7075	Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Lot: 346081	Min			1.2		2.1	0.18	5.1				

- Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No ->	UTS	TYS	EL4D
T7351	Long Transv.	Test	KSI	KSI	PCT
		3	73.2	62.6	10.9
			73.4	62.6	10.6
			73.4	58.3	11

T7351 Elect Cond %IACS 40.9 41.3 41.0 PCT

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9420126	Actuals	0.06	0.27	1.6	0.02	2.5	0.19	5.7	0.03

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

Cust: THYSSENKRUPP MATERIALS NA - ECAD Del: 2401728616
Part: PO: PEC - 237319
Mgt: 379.622 LB Date: 03/02/2012

James H. Baker